

5/30

DART AEROSPACE LTD	Work Order:	23730
Description: Bracket	Part Number:	D3199-1
TT 05.07.04		
Dwg: D3199 Rev. A1	Qty:	97 100
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	PF	05.07.04	100
2	PG	Issue P/O: <u>2008316</u> Email or Ship DXF file to vendor Laser Cut D3199-1 bracket per Dwg D3199 Material release note is required	PL	05.07.05	100
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	DC	05/07/28	100
4	QC6	Inspect dimensions as per Dwg D3199 Identify as D3199-1	2	05/08/23	100
5	GA	Deburr if necessary	SAC	05/08/24	100
6	GB	Form as per Dwg D3199	SB	05/09/13	100
7	GA	Scribe Part number as indicated on Dwg D3199	N/A		
8	QC5	Inspect work to Step 6	J	05/09/14	100
9	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3	FC	05/09/21	100
10	QC3	Inspect Powder Coat	M	05/09/21	100
11	ST	Identify and Stock	DC	05/09/22	97
12	AC	Cost / part <u>6.24</u>	SAC	05.09.26	87
13	DC	Close W/O <u>6,08</u> Inspect Level 21	PF	05/09/26	77

Rev	Date	Change	Revised By	Approved
A	03.10.02	New Issue	KJ/RF	
B	03.10.23	Added Step 7	KJ/RF	#

RELEASED

04.01.09 PF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05/09/13	6	The measure .409 change to $.40 \pm .030$ as per attached E-mail.	SB	05/09/13		VB 05/09/13	J 05-05-14	
05-09-14	7	Part number is scribed on clamping fixture cut process, eliminate step 7. <u>Permanent change</u>				VB 05/09/14	J 05-05-14	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-09-08	4	Parts are 0.020" under vertical measurement of 2.971".	AB 05-09-08	final bend dimensions are good. parts Accepted.	AB 05-09-08	J 05-09-08	AB 05-09-08	J 05-09-08
05-09-14	6	1 part scrapped. die damage on part.	AB 05-09-14	Scrap. destroy	J 05-09-14	J 05-09-14	AB 05-09-14	J 05-09-14

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

DQA:

Date: 05/09/14

NOTE: Date & initial all entries

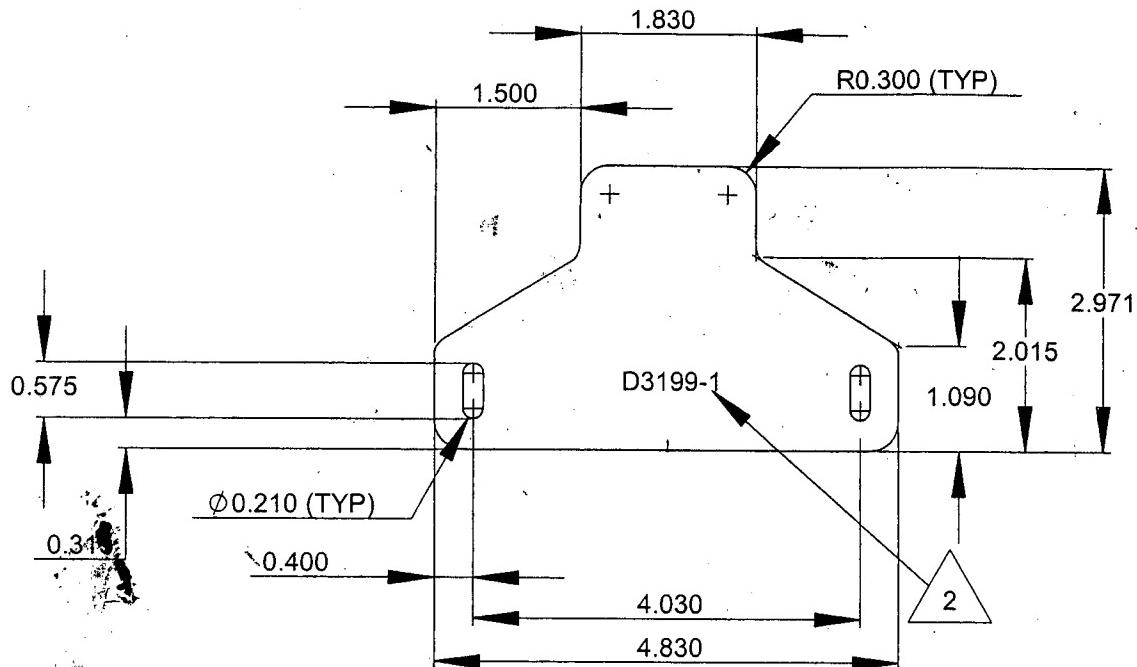
QA: N/C Closed: _____

Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3199	REV. A	SHEET 1 OF 1
DATE 03.08.05	TITLE BRACKET	SCALE 1:2		
A	03.08.05	NEW ISSUE		
A1	04.03.01 <i>CP</i>	Z-24 WAS Z-142		

RELEASED
03-09-02



D3199-1 FLAT PATTERN

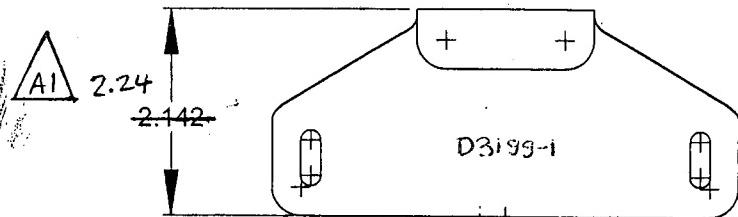
SHOP/COPY

RETURN TO
ENGINEERING

~~UNCONTROLLED COPY~~

WORLD BORDER

23730



D3199-1 BRACKET

The technical drawing illustrates a structural corner detail. Key dimensions include a vertical height of 1.70, a horizontal distance of 409, and a radius of R0.250. An angle of 15° is indicated at the top left. Horizontal distances of 0.677 and 0.962 are shown at the bottom right. The drawing is labeled "UNCONTROLLED COPY" and includes a work order number 23730.

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
 - 2) SCRIBE DART P/N D3199-1 AS SHOWN.
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 30, 2005
02:06 pm

Work Order No.	:	0023730	Department Code:	
Project Name	:	D3199-1	Burden Flags	: NNNNNNN
Project For	:	WK530	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3199-1	Invoice Number	:
Description	:	Bracket	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	100	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	06-30-05	Est Mark Up	: 0.000%
Est Finish Date	:	07-30-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:			\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	
Misc.	:	0.00	0.00	0.00	0.00
<hr/>					
Burden	:	0.00	0.00	0.00	
<hr/>					
Total Cost	:	0.00	0.00	0.00	
Mark up	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/(Loss)	:	0.00	0.00

Linda Lacelle

From: "David Shepherd" <davids@dartaero.com>
To: <robertof@dartaero.com>
Cc: "Linda Lacelle" <lindal@dartaero.com>
Sent: Tuesday, September 13, 2005 10:32 AM
Subject: D3199-1

With respect to the 0.409 dimension, +/- 0.030 tolerance is acceptable for this batch.

David